

PART LIST			
QTY	PART NUMBER	DESCRIPTION	
-041	X D3651-041	AFT BASE ASSEMBLY	
1	D3651-043	FLANGE WELDMENT	
1	D3651-1	GASKET	
1	D3651-9	INSIDE DOUBLER	
1	D3651-11	GASKET	
1	D3651-13	OUTSIDE DOUBLER	
58	CR3523-4-02 or NAS9307M-4-02	RIVET	

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:
 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50-0.88 SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	
MFG. APPR.	RF	D3651	
APPROVED	RF	TITLE	
DE APPR.	RF	AFT BASE ASSEMBLY	
DATE	08.01.07	SCALE	

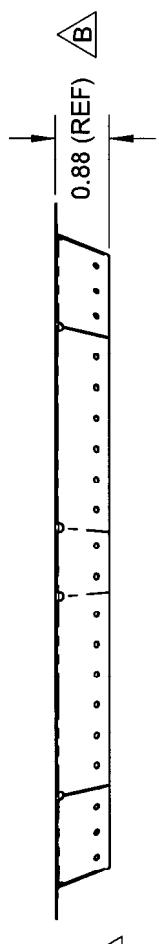
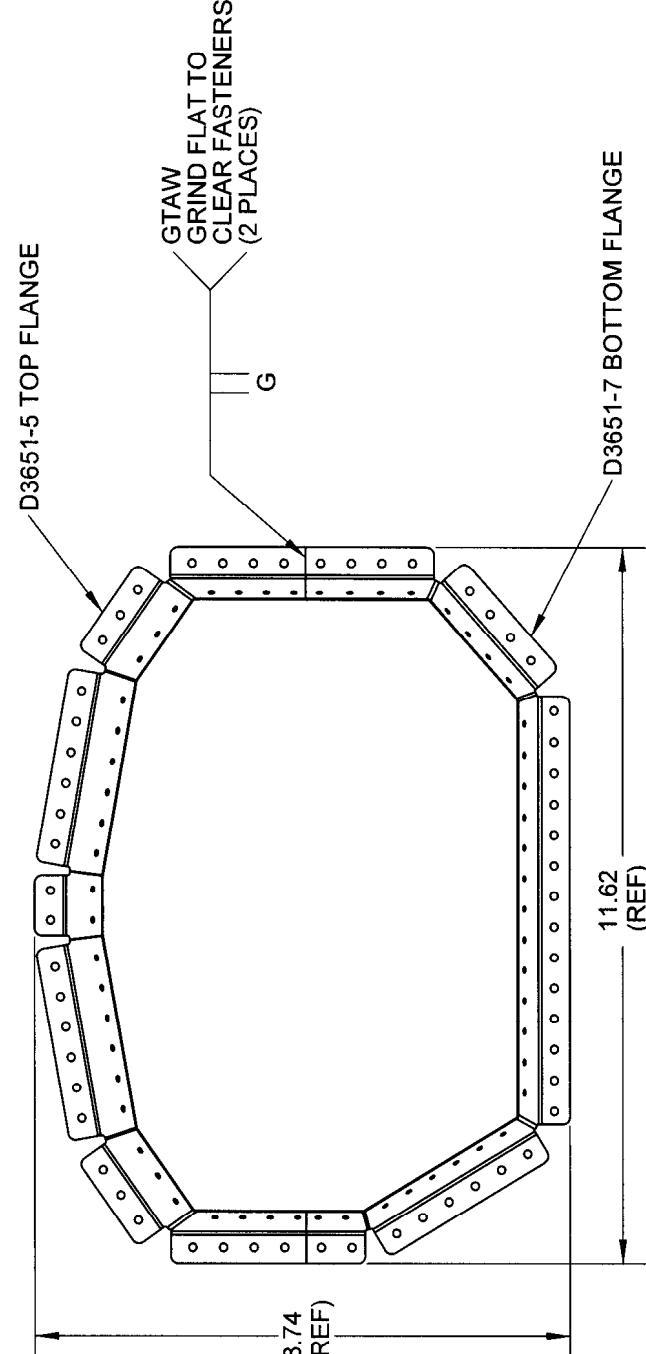
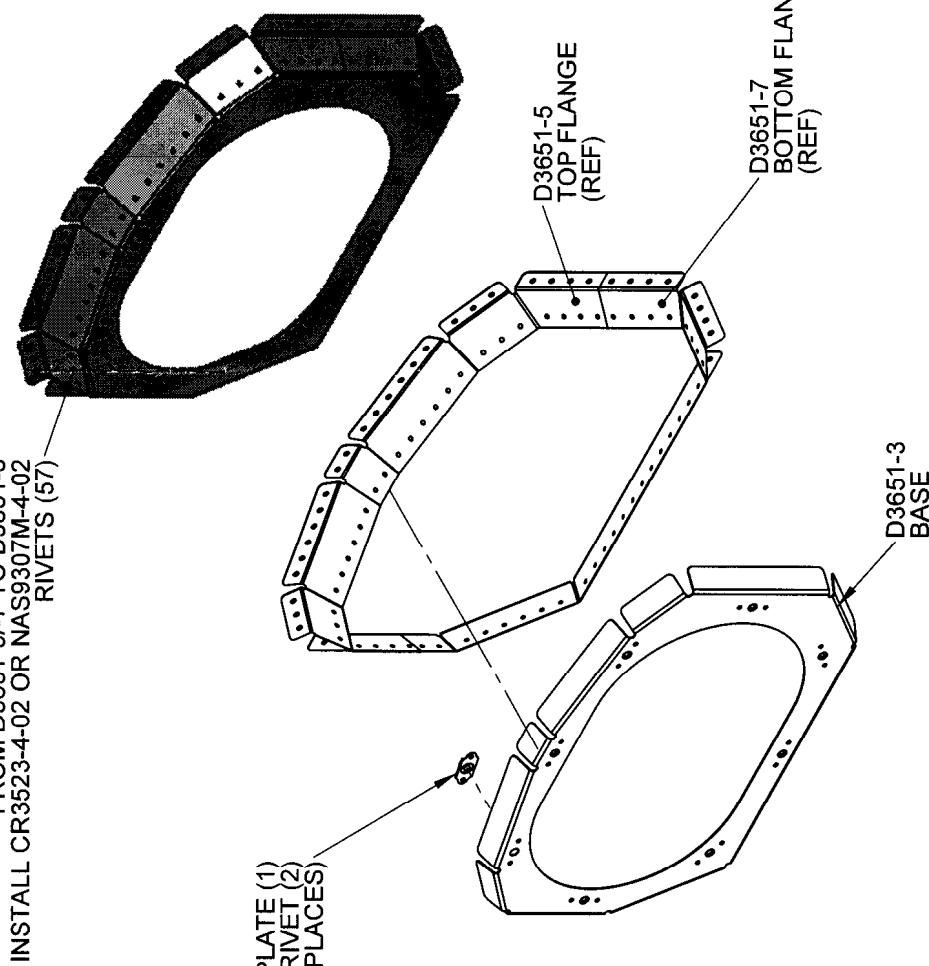
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203-2711

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TRANSFER DRILL \varnothing 0.1129 (#30 DRILL)
FROM D3651-5-7 TO D3651-3
INSTALL CR3523-4-02 OR NAS9307M-4-02
RIVETS (57)



QTY	PART NUMBER	DESCRIPTION
-043		
X	D3651-043	FLANGE WELDMENT
1	D3651-3	BASE
1	D3651-5	TOP FLANGE
1	D3651-7	BOTTOM FLANGE
16	MS20427M3-3	RIVET
8	MS21060-3K	NUTPLATE
57	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-043 FLANGE WELDMENT

08.03.27 M

D3651-043 NOTES:
1) WELD PER QSI 004
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.76 lbs

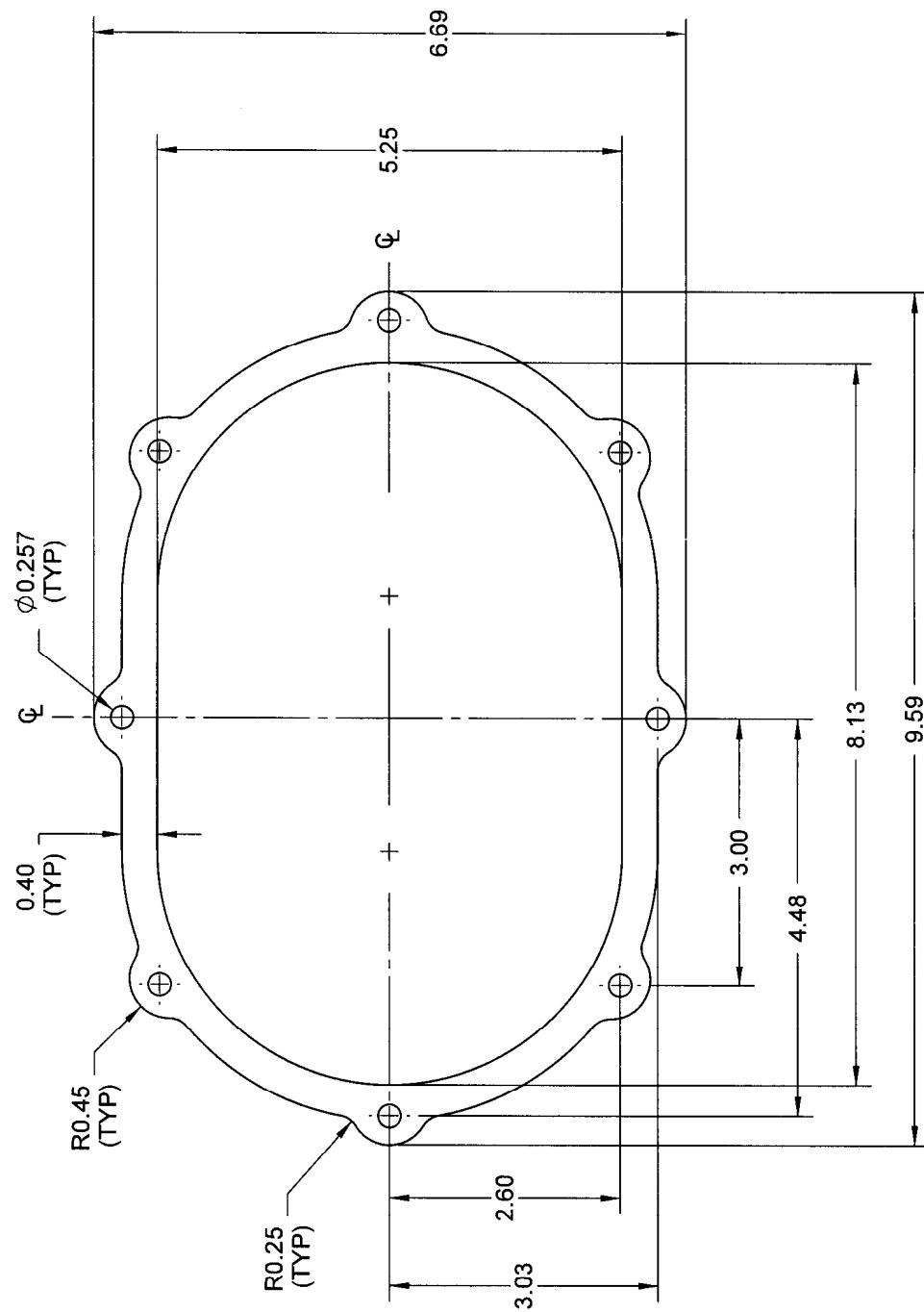
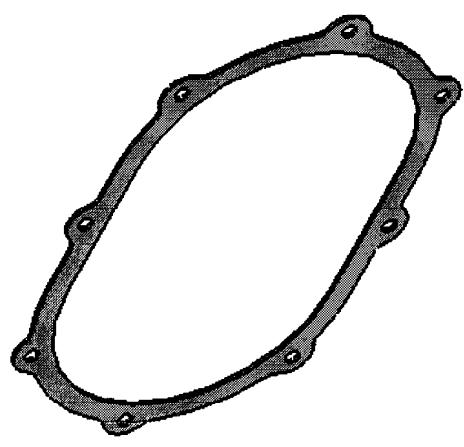
D3651-043 NOTES:
1) WELD PER QSI 004
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.76 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	LE	DRAWING NO.
MFG. APPR.	JK	D3651
APPROVED	JK	TITLE
DE APPR.	JK	AFT BASE ASSEMBLY
DATE	08.01.07	08.03.27 M

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REV. B
SHEET 2 OF 9
SCALE



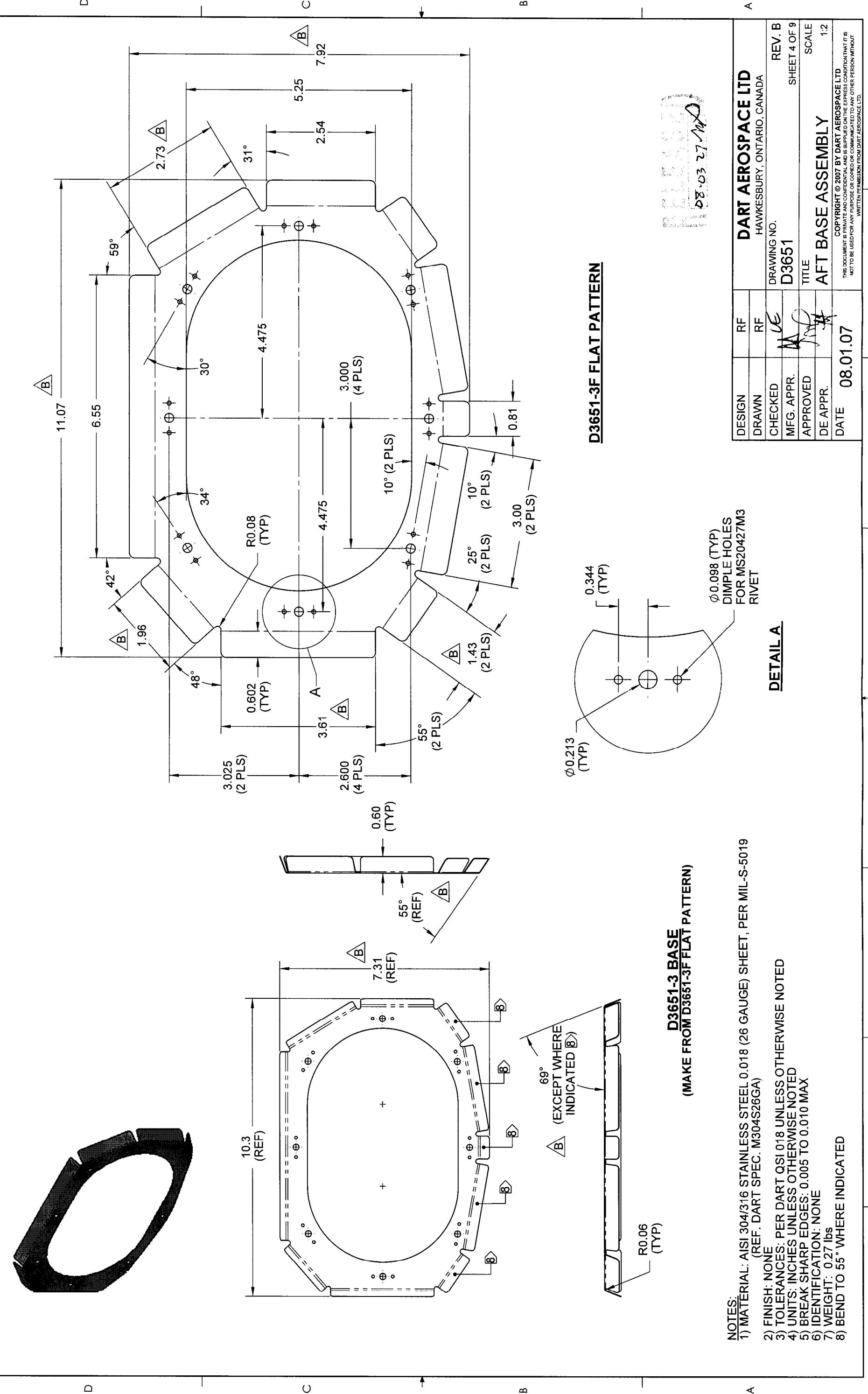
D3651-1 GASKET

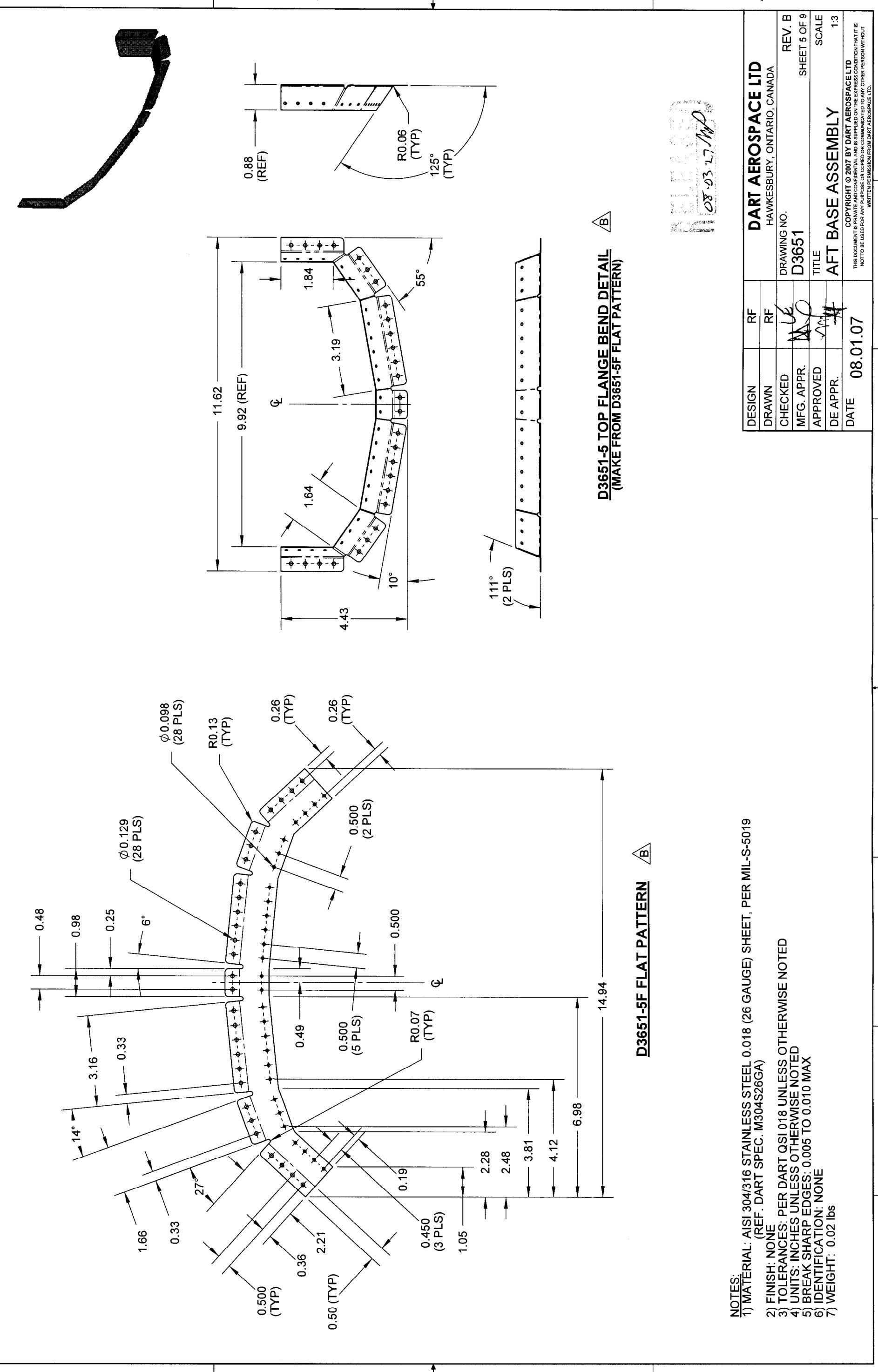
NOTES:
 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) PART IS SYMMETRIC ABOUT ϕ
 8) WEIGHT: 0.09 lbs

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	
D3651	
REV. B	
SHEET 3 OF 9	
SCALE	
1:2	

28-03-27 M

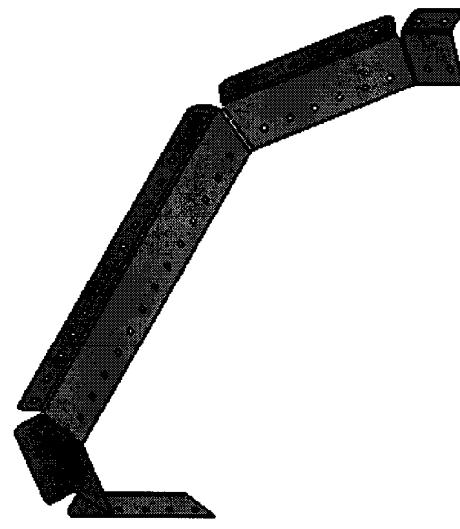
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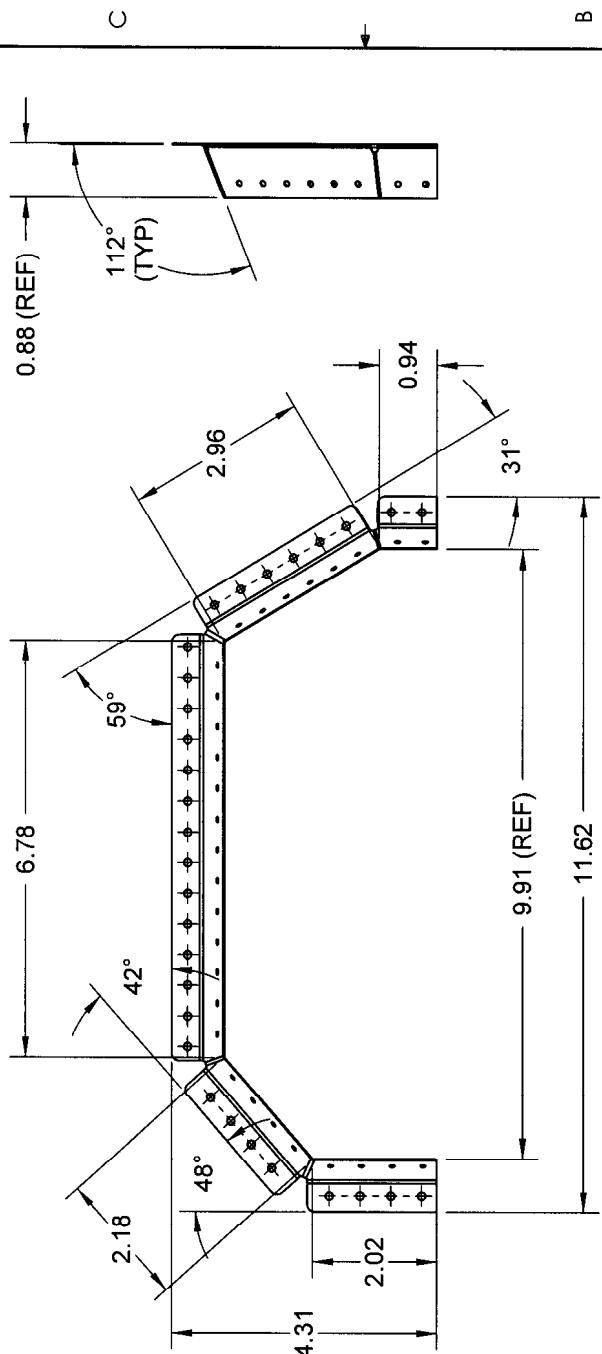


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CHECKED	<i>W</i>	<i>W</i>	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	<i>W</i>	<i>W</i>	DRAWING NO.
APPROVED	<i>W</i>	<i>W</i>	D3651
DE APPR.	<i>W</i>	<i>W</i>	TITLE
DATE	08.01.07	1	AFT BASE ASSEMBLY

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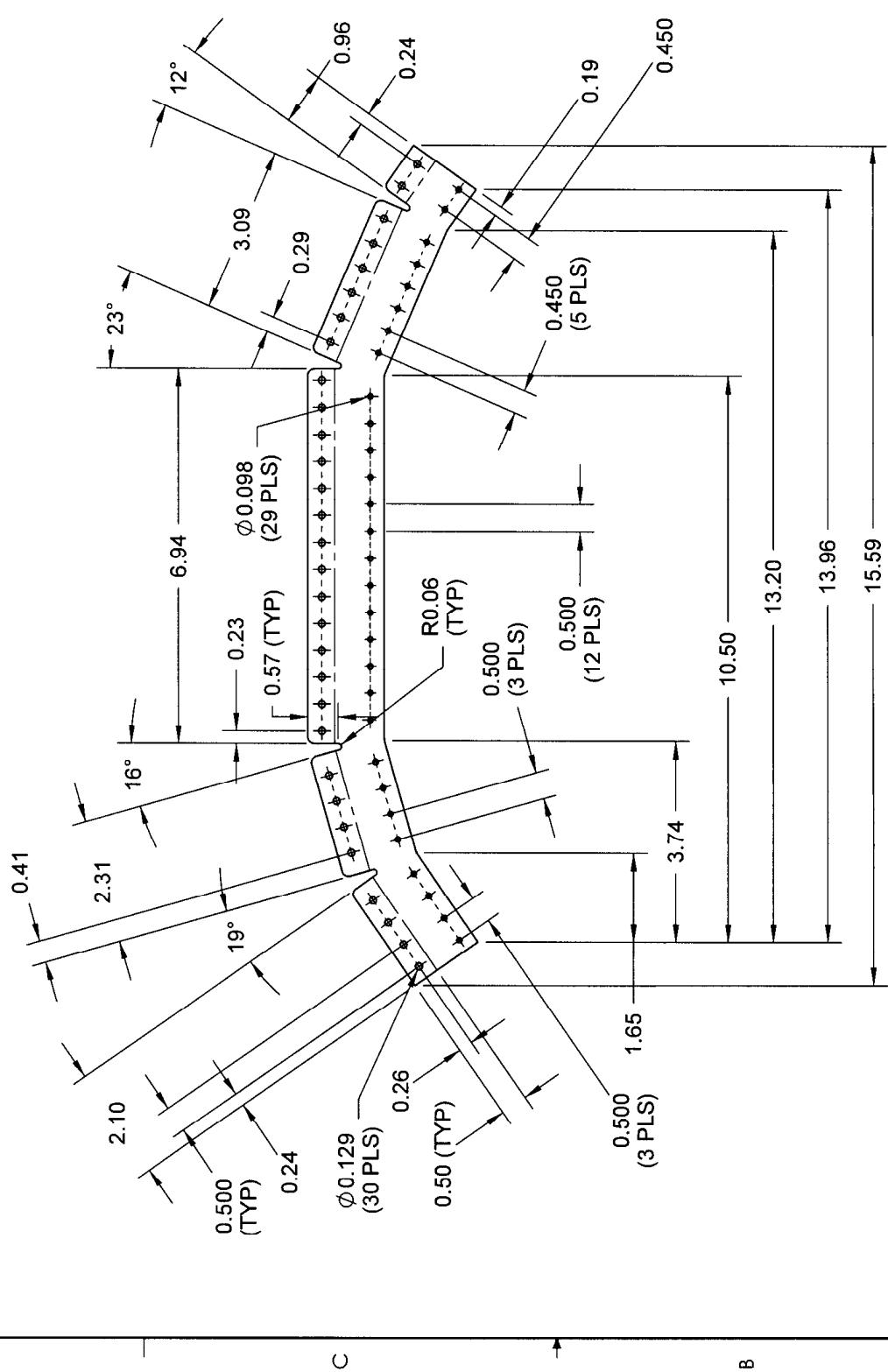


D C B A



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

D3651-7F FLAT PATTERN B



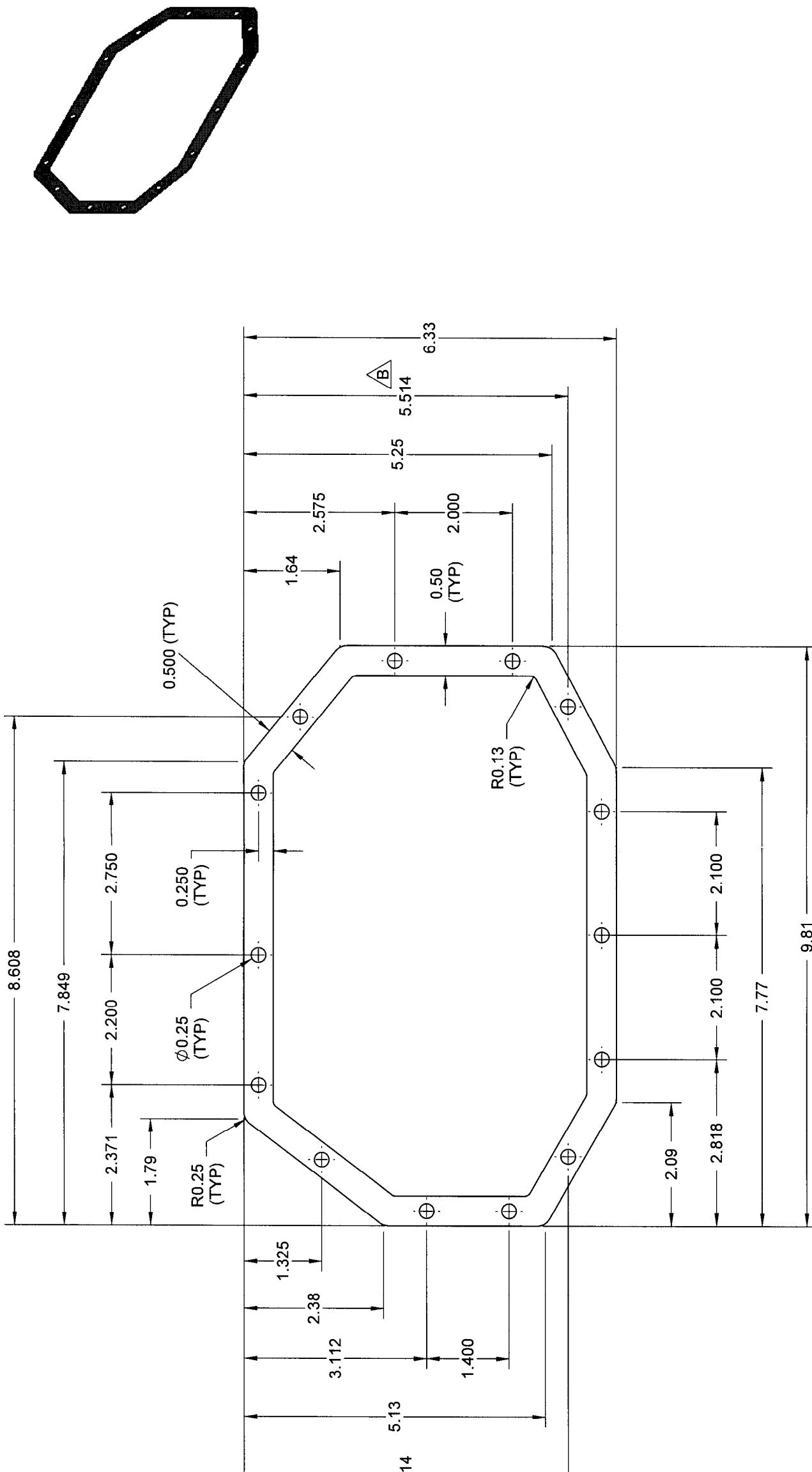
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN DRAWN	RF	DART AEROSPACE LTD
CHECKED	RF	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	✓	DRAWING NO.
APPROVED	✓	D3651
DE APPR.	✓	REV. B
DATE	08.01.07	SHEET 6 OF 9
		SCALE 1:3

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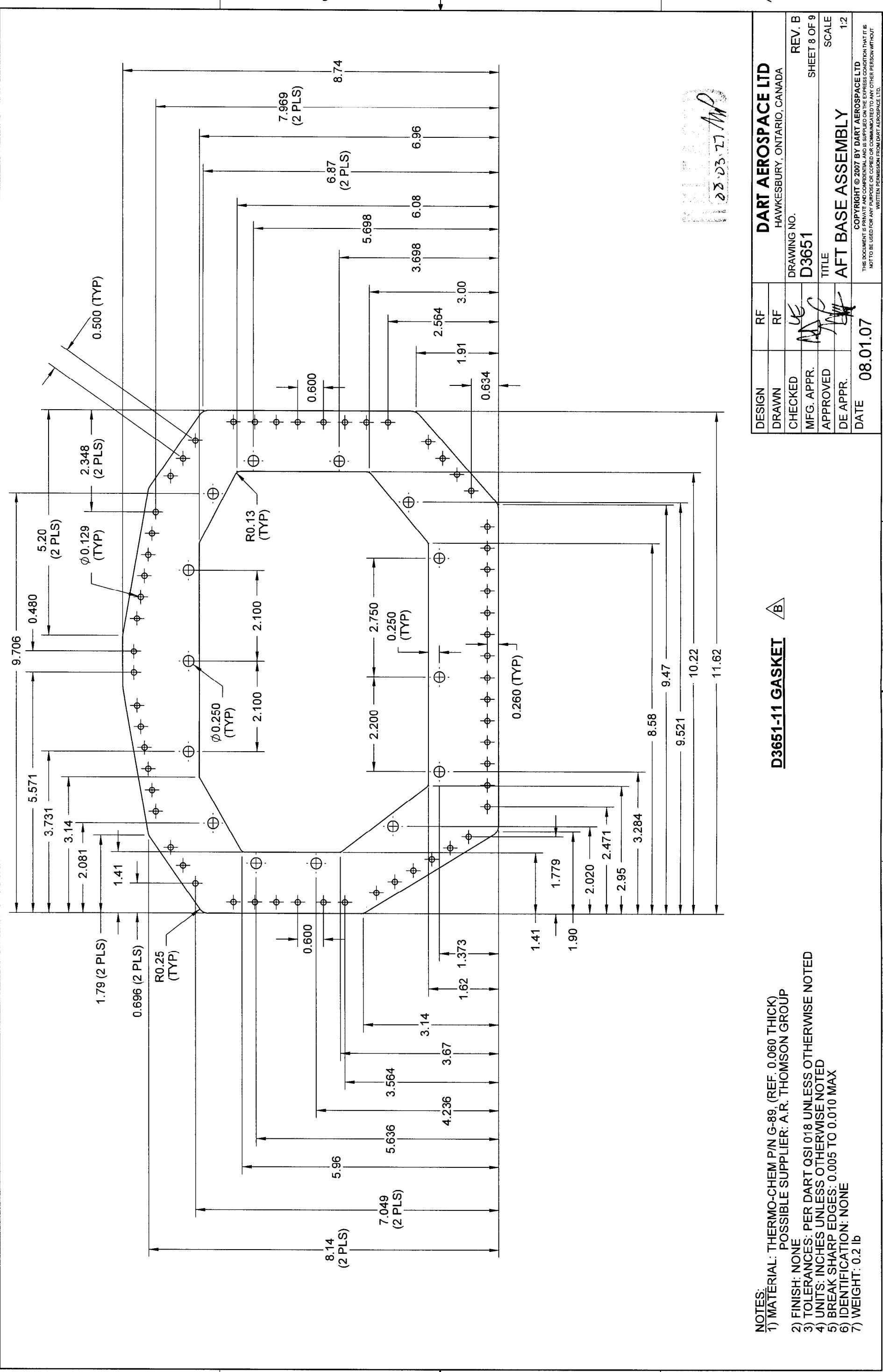


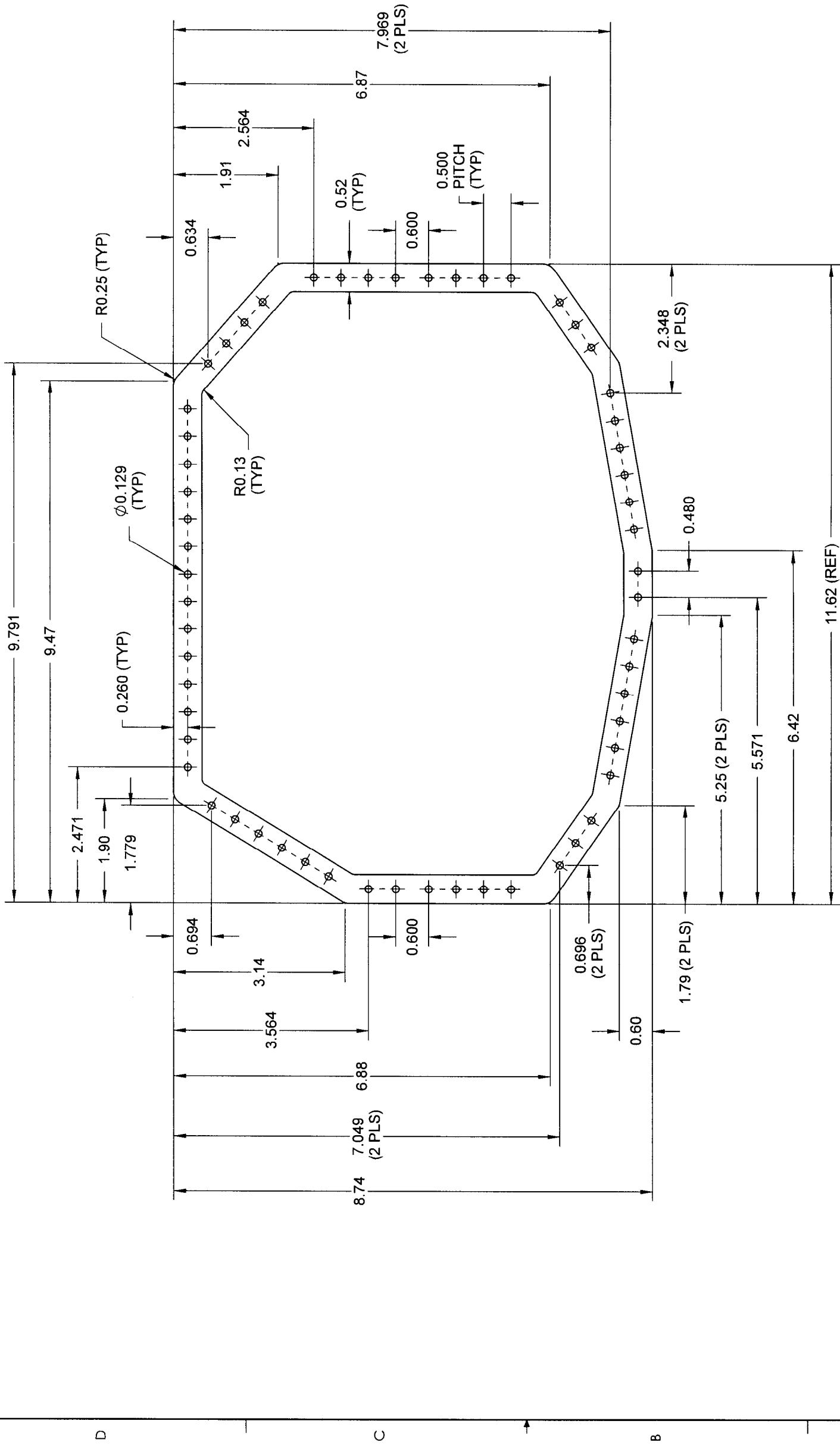
D3651-9 INSIDE DOUBLER

NOTES:
(11) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
(2) FINISH: NONE
(3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
(4) UNITS: INCHES UNLESS OTHERWISE NOTED
(5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
(6) IDENTIFICATION: NONE
(7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>W</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>W</i>	D3651	SHEET 7 OF 9
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	AFT BASE ASSEMBLY	1:2
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NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.10 lbs

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DESIGN	RF
DRAWN	RF
CHECKED	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	DRAWING NO.
APPROVED	D3651
DE APPR.	TITLE
DATE	AFT BASE ASSEMBLY
	08.01.07
RF	REV. B
RF	SHEET 9 OF 9
	SCALE
	1:2
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